

Date: Tuesday, 10/2/2007 1:20:05 PM
 User: Kim Johnston

Process Sheet

42

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : FWD X-TUBE EXTENDED HEIGHT GEAR (-011)
Job Number : 34945	
Estimate Number : 10007	
P.O. Number : N/A	Part Number : D205596101
This Issue : 10/2/2007 S.O. No. : N/A	Drawing Number : D205-596-101 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A	Drawing Revision : A
Previous Run : 32941	Material : N/A
Type : LANDING GEAR	Due Date : 10/20/2007 Qty: 1 Um: Each
Written By : <u>[Signature]</u>	
Checked & Approved By : <u>[Signature]</u>	
Comment : Est Rev G Removed Bending 05-10-25 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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DSI 9396
 KS, 07.11.07

Comment: DOCUMENT CONTROL

Photocopy D205-594 bluefile & type labels per PPP D205-596-101 CHG001

02
 6 07/12/10

2.0	D2889	FWD Crosstube
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

FWD Crosstube

Pick:

Qty Part number Description Batch

1 D2889 Fwd Crosstube

B35299

EL 7-10-23

3.0	BENDING	BENDING MACHINE
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Comment: BENDING MACHINE

Bend as per Dwg D2889

EL 7-10-23

4.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

Mark 31.53" for cutting from tangential line in the straight section from D2889 as per Dwg wall template.

Identify off-cuts with batch number & part number and bring them to cnc lathe

EL 7-10-23

5.0	QC15	DIMENSIONAL CHECK OF X-TUBES
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Comment: DIMENSIONAL CHECK OF X-TUBES

07-10-23 @

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
07.12.06	13	MS 21920-24 CLAMPS USED INSTEAD OF -26				 07.12.06 PC 051042		

•Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: PD Date: 07/12/11
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD X-TUBE EXTENDED HEIGHT GEAR (-011)

Job Number: 34945

Part Number: D205596101

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Cut as per Dwg D205-596-101

— EL 7-10-23

AWM 07-10-26

2-Deburr & Inspect for surface damage. Polish cut surface. Scribe part # and
end of tube.

Batch # on one

7.0

QC15

DIMENSIONAL CHECK OF X-TUBES



Comment: DIMENSIONAL CHECK OF X-TUBES

checked by kt 07/11/05
A-11-21 (1)

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat per QSI 005 4.1

AWM
07-10-30 JD

9.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

Prime inside and outside with Immron per QSI 005 4.2

75 07-11-28

10.0

QC14

INSPECT SPRAY PAINT



Comment: Inspect Spray Paint

ml 07 12 04

(1)

11.0

D2856600851

Abrasion Strip



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Abrasion Strip

Pick:

Qty Part number

Description

Batch

2

~~D2856-890-851 Abrasion Strip~~

35124

ml 07 12 04

Rubber cushion

12.0

D28931

Support



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Support

Pick:

Qty Part number

Description

Batch

2

D2893-1

Support

32779

ml 07 12 04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 10/2/2007 1:20:05 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD X-TUBE EXTENDED HEIGHT GEAR (-011)

Job Number: 34945

Part Number: D205596101

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

MS2192024

Clamp(per MIL-DTL-8783C)



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number

Description Batch

4 MS21920-24

Clamp

103955

ml 071204

Leave as-is

AB

14.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Time: 5:00pm

3105379 exp: 2008/04



ml 071204

Comment: LANDING GEAR RESOURCE 1

1-Install Abrasion strips per QSI-035 position using DT9582. Install supports and clamps per Dwg

D205-596-101. Torque clamps to 80-100 in lb. Seal edges of support using Sikaflex

Magna bond

per OSI 9396

see 2/12/07

ml 071204

per 2/12/07

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

2/12/07

AB

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D205-596-101

Location:

F

7/12/10 50

AB

17.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

2/12/11

Job Completion



min 20071211 02

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
07-12-03	13	DSF states -26 but leave as -24 Eng will be notified				<i>[Signature]</i> 6-12-03	<i>[Signature]</i> 6-12-03	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

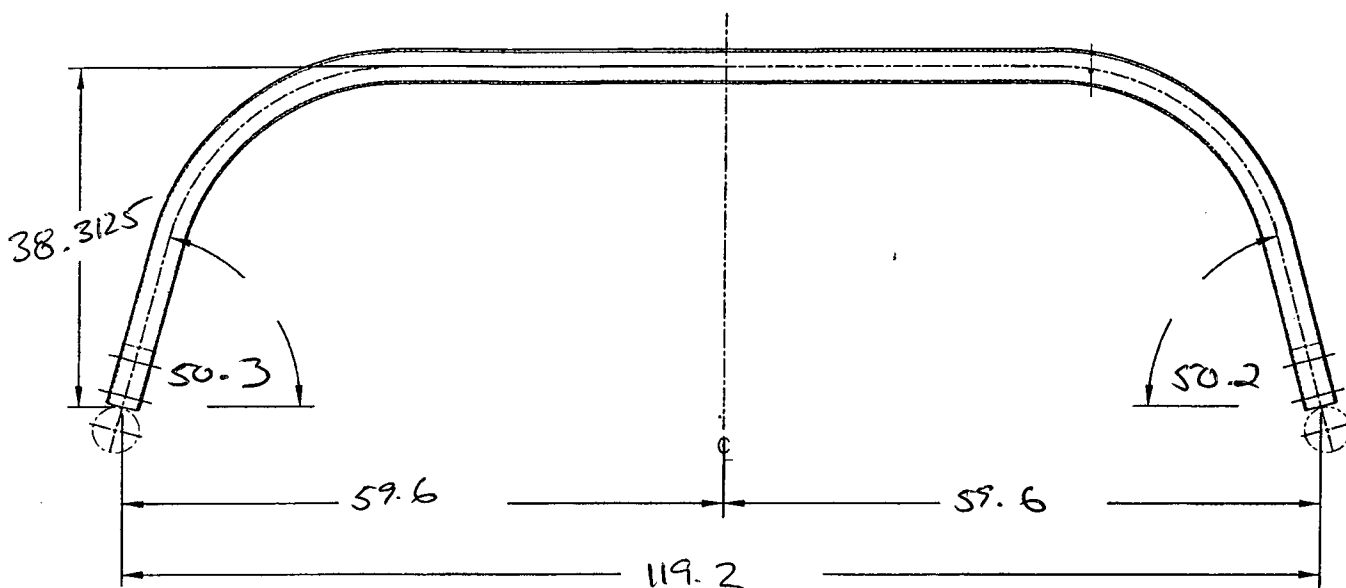
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	34945
Description: Crosstube High-High Fwd		Part Number:	D205-596-101
Inspection Dwg: D205-596-101 Rev: A		Page 1 of 1	

Required Dimension	Min	Max
Height	38.2	38.4
1/2 Span	59.5	59.7
Angle	49	52
Total Span	119.0	119.4

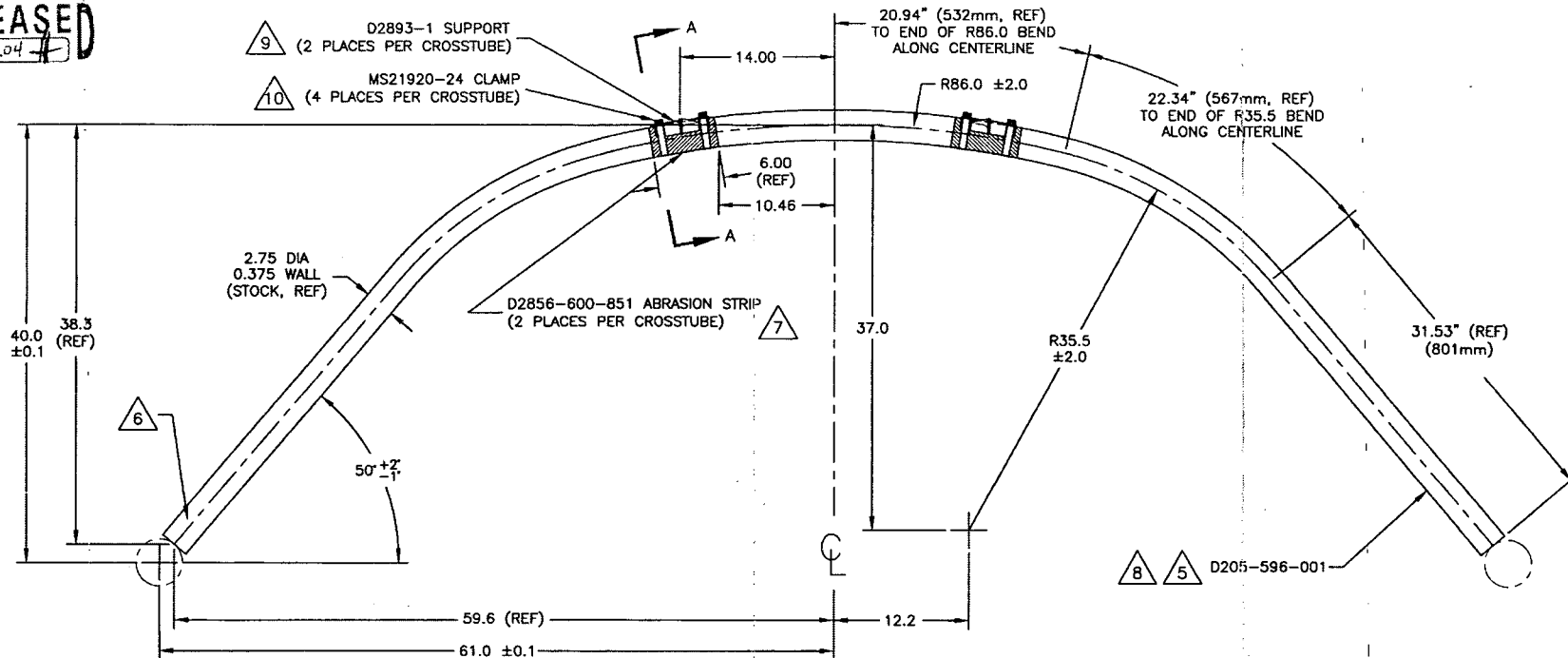


Comments

QC15 Inspection	
Date	07.10.23

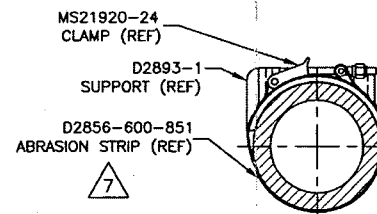
Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	

RELEASED
02.06.04



GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) MATERIAL: MANUFACTURE FROM D6005-180
FINISHED LENGTH = 149.60
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) BEND PROGRESSIVELY WITH A MINIMUM OF 3 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 6) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS
- 7) INSTALL D2856-600-851 ABRASION STRIP WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D2893-1 SUPPORT, PER QSI 035
- 8) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005\"
- 9) SEAL EDGES OF SUPPORTS USING SIKAFLEX-241/-291 SEALANT (OPTIONAL)
- 10) TORQUE CLAMPS 80 TO 100 IN.-LB



SECTION A-A
SCALE 2:5

A		02.05.27	NEW ISSUE
DESIGN	✓	DRAWN BY	CP
CHECKED	✓	APPROVED	✓
DATE	02.05.27	TITLE	XTUBE ASS'Y (HI-HI FWD)
COPYRIGHT © 2002 BY DART AEROSPACE LTD.		DRAWING NO.	D205-596-101
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		REV. A	SHEET 1 OF 1
		SCALE	1:10

NO
34945
WORK ORDER
WITHOUT NOTICE
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
ENGINEERING
RETURN TO
SHOP COPY

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D205-594 Rev. C (AND EARLIER) AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D205-594 Rev. 2 (AND EARLIER)
REF. CANADIAN STC: SH03-6
REF. FAA STC: SR01742NY

For D205-596-101/-103 Crosstubes (ref. 39" Landing Gear) or D205-596-105/-107 Crosstubes (ref. 31" Landing Gear) at CHG 002 or later, the D2856-600-851/-1009 Abrasion Strips have been removed, the D2893-1 and D2940-1 Supports have been bonded onto the crosstubes using Magnobond 6398 and D3595-063-450/-530 Rubber Cushions have been installed underneath the MS21920-26/-30 Clamps. Amend Parts List of IIN-D205-594 Section 5 and ICA-D205-594 Section 32.8 as follows:

Remove:

QTY -101	QTY -103	QTY -105	QTY -107	Part Number	Description
2		2		D2856-600-851	ABRASION STRIP
4		4		MS21920-24	CLAMP
	2		2	D2856-600-1009	ABRASION STRIP
	4		4	MS21920-28	CLAMP

Add:

QTY -101	QTY -103	QTY -105	QTY -107	Part Number	Description
4		4		D3595-063-450	RUBBER CUSHION
4		4		MS21920-26	CLAMP
	4		4	D3595-063-530	RUBBER CUSHION
	4		4	MS21920-30	CLAMP

To prevent the supports from shifting on D205-596-101/-103/-105/-107 Crosstubes at CHG 001, the D2893-1 or D2940-1 Supports should be removed and re-installed as follows:

- Follow section 32.1 of ICA-D205-594 for the removal of the crosstubes from the helicopter.
- Remove the MS21920-24/-28 Clamps that fasten the D2893-1 and D2940-1 Supports from the crosstubes per Section 32.3 of ICA-D205-594.
- Remove the D2856-600-851/-1009 Abrasion Strips from the crosstube per section 32.5 of ICA-D205-594.
- Inspect the crosstube surface underneath the supports for corrosion and mechanical damage per items 5.3.1 and 5.3.2 of the 300 hour inspection. Repair damage within acceptable limits and touch up finish per item 5.3.3 of the 300 hour inspection.
- Inspect the supports for corrosion and mechanical damage per items 5.3.4 of the 300 hour inspection. Repair damage within acceptable limits and touch up finish per item 5.3.4 of the 300 hour inspection.
- Abrade area to which support will be applied with 400 grit sandpaper. Saturate a clean cloth with MEK or 4105S Wash'n'Wipe Degreaser or equivalent and wipe area until there is no residue.
- Apply a 0.03" to 0.06" thick layer of Magnobond 6398 underneath D2893-1 or D2940-1 Supports and re-install the Supports on the crosstube as shown in Figure 1. Install a D3595-063-450/-530 Rubber Cushion on each MS21920-26/-30 Clamp. Position and secure the D2893-1 or D2940-1 Supports on the crosstube using MS21920-26/-30 Clamps. Torque clamps to 80-100 in-lb. Let the D205-596-101/-103/-105/-107 Crosstube Assembly cure before re-installing the crosstube on the aircraft.
- Re-install the D205-596-101/-103/-105/-107 crosstube per section 32.2 of ICA-D205-594.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 07.11.16

CERT. NO.: SH03-6

ISSUE NO.: 3

A	NEW ISSUE	MB	07.11.16
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		DSI 9396	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		CROSSTUBE SUPPORT CHANGE	NTS
DATE	07.11.16	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

For customers who would like to upgrade their D205-596-101/-103/-105/-107 Crosstubes from CHG 001 to CHG 002, the following kits can be obtained from Dart:

DSI 9396-XXX PARTS LIST

QTY -011	QTY -013	Part Number	Description
X		DSI 9396-011	FWD CROSSTUBE SUPPORT CHANGE (D205-596-101/-105 FWD CROSSTUBE)
	X	DSI 9396-013	AFT CROSSTUBE SUPPORT CHANGE (D205-596-103/-107 AFT CROSSTUBE)
4		D3595-063-450	RUBBER CUSHION
4		MS21920-26	CLAMP
	4	D3595-063-530	RUBBER CUSHION
	4	MS21920-30	CLAMP

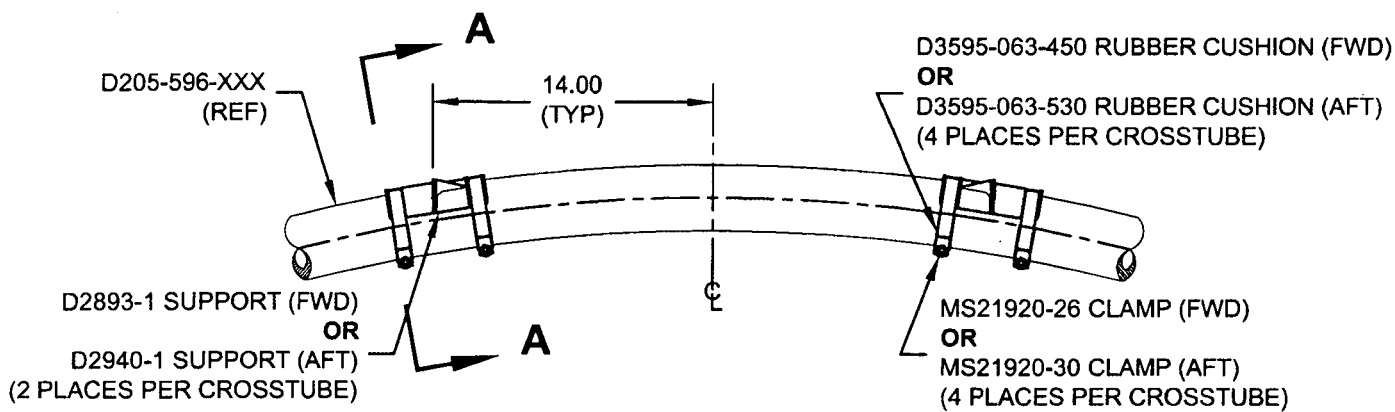
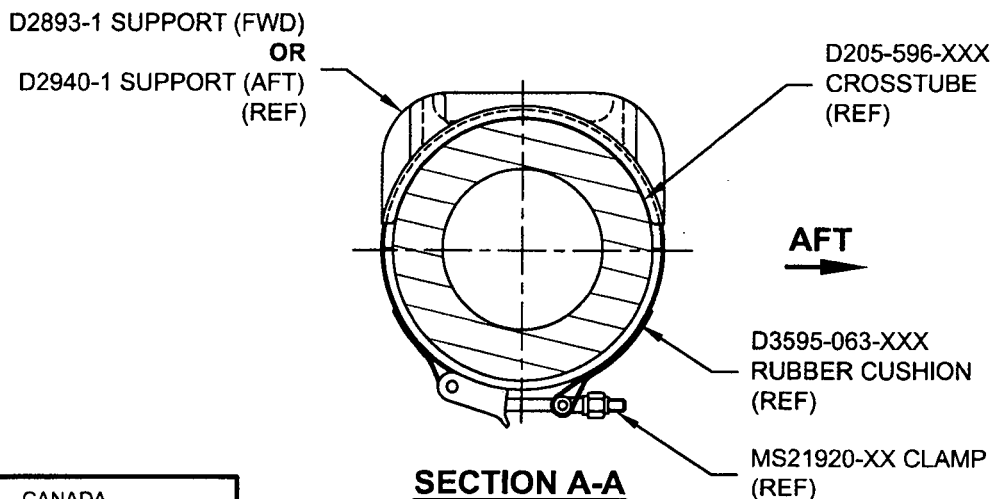


FIGURE 1: INSTALLATION OF SUPPORT ON CROSSTUBE



SECTION A-A

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 07.11.16
CERT. NO.: SH03-6
ISSUE NO.: 3

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	<i>[Signature]</i>	
CHECKED	<i>[Signature]</i>	DRAWING NO. _____
MFG. APPR.	<i>[Signature]</i>	DSI 9396
APPROVED	<i>[Signature]</i>	TITLE
DE APPR.	<i>[Signature]</i>	CROSSTUBE SUPPORT CHANGE
DATE	07.11.16	SCALE
		NTS

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REV. A
SHEET 2 OF 2